

Work Order ID 110475

December-20-13 9:07:42 AM

110475

Page 1

Item ID: D350-636-012

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 1/03/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 13-12-20 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2750-042	G								
D3492	C								

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

record fwd angle: 88.9°

Photocopy blue file and type labels per PPP D350-636-012 CHG 007

B110475RH

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Item ID: D350-636-012

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Start Date: 12/20/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 1/03/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00

110

Skidtubes

0.00

Skidtubes

Skidtubes

Memo

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.
SECOND SIDE

8- Open up holes for Detail "K" to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail L to 0.500" (8 holes per side)

9- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10- Open up holes of Detail J to 0.297" (total of 2 holes per side)

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Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Stop *NS2*

Start Date: 12/20/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 1/03/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left
from bending as per QSI 004

A/R Aluminum Rod batch: M127069

12-Grind welds flush as per Dwg D2750

BE 11/01/27

120	QC10- Inspect visual per QSI004- ground welds	0.00							DAS
-----	---	------	--	--	--	--	--	--	-----

120

QC

Memo

0.00

Quality Control

① 11-01-27

DAS
9
9-89

130	QC5- Inspect part completeness to step on W/O	0.00							DAS
-----	---	------	--	--	--	--	--	--	-----

130

QC

Memo

0.00

Quality Control

① 11-01-27

DAS
9
9-89

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Item ID: D350-636-012 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13 Start Qty: 1.00 *1* Cust Item ID:

Required Date: 1/03/14 Req'd Qty: 1.00 *1* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00							
150									
QC	Memo	0.00							
Quality Control									

DA 8
12
14-01-27

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Item ID: D350-636-012

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 1/03/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
160	Skidtubes	0.00								
160										
Skidtubes										
Skidtubes	<div><div>Memo</div><div>1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.</div><div>2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.</div><div>3-Open float holes to .500" (4 per Side)</div><div>4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)</div><div>5-Deburr and blow out all chips from inside of tube</div><div>6-Prepare tube for welding, remove alodine as required.</div><div>7-Bond web D2739 in place as per QSI 015 A/R Sikaflex-291 batch: 177077 exp. date: 148-16</div><div>8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9) A/R Aluminum Rod batch: M127009</div><div>9- At section AP-AP drill out x-bolt spacer to 0.404"</div><div>10 Grind welds flush as per Dwg D2750</div><div>11 Spot face ground handling holes section (total of 4 places per side) as per</div></div>	0.00								

14-1-27 DL

> 8214-1-29

mm 14/01/29

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Item ID: D350-636-012

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N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13

Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/03/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

dwg D2750

12-Deburr holes

mm

14/01/29

170

QC10- Inspect visual per QSI004- ground welds

0.00

170

QC

Memo

0.00

Quality Control

①

14.0.30

DAS

9

9-89

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

VERIFY C'BOARD IS GOOD

①

14.0.30

DAS

9

9-89

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Start Date: 12/20/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 1/03/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190

Pressure Wash per QSI005 4.3

0.00

190

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

1 RG 14-1-30

200

0.00

200

SprayPaint

Memo

0.00

Spray Painting

1- PRIME AS PER DWG AND QSI 005 4.2

PRIMER PRC DESOTO 515X349 BATCH: 126543

2- PAINT WHITE AS PER DWG AND QSI 005 4.2

PAINT BATCH: 128009

1 C.R. 14-2-13
AS

210

QC14- Inspect Spray Paint

0.00

210

QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

1 mtw 14-02-14

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Item ID: D350-636-012

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N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/03/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	HandFinishing	0.00							
230	HandFinish	0.00							
Hand Finishing	Memo								
	1-Install inserts as per dwg D2750								
	2-Inspect for Foreign Objects								
	3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: <u>11127918</u> EXP DATE: <u>1410</u>								
	4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: <u>11121651</u>								
	5-Coat all exposed fasteners with "LPS Procyon" batch: <u>11122506</u>								
240	QC5- Inspect part completeness to step on W/O	0.00							
240	QC	0.00							
Quality Control	Memo								

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N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13

Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/03/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

250

Pick Kit

0.00

250

Packaging

Memo

0.00

Packaging

1x DAS 28 14-02-20 9-89

260

QC4- 100% Inspect kits for completeness

0.00

260

QC

Memo

0.00

Quality Control

DAS 31 14-02-21 9-89

270

Packaging

0.00

270

Packaging

Memo

0.00

Packaging

Package as per PPP D350-636-012

072

DAS 28 14-2-29 6 9-89

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Item ID: D350-636-012**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** Skidtube RH Aerazur / Apical Cylindrical Compat.**Start Date:** 12/20/13 **Start Qty:** 1.00 ***1*****Cust Item ID:****Required Date:** 1/03/14 **Req'd Qty:** 1.00 ***1*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

280	QC21- Final Inspection - Work Order Release	0.00							
-----	---	------	--	--	--	--	--	--	--

280

QC

Memo

0.00

Quality Control

14-02-27

14-02-27

Picklist Print

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Work Order ID: 110475

110475

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:102.09.25Rearranged procedure stepsKJ
 IPP Rev:J 06-03-29 As per Rev D EC IPP REV:K
 AS PER REV F JLM 13-08-22 VERIFIED BY:DD
 IPP Rev:K 06-07-13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
 IPP Rev:M 08-04-22 update steps 4,13 DD verified by:EC
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O
 10.06.22 revise seq110 DD verf:EC IPP Rev:P 10.10.01 as
 per IIN revH DD verf:EC IPP REV:Q 13.08.27 PER ECN13-
 594 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-3-BENT		Manufactured	No			110	Each	5.0000	1	1			
D2600-3-BENT									**				
Extrusion Bent													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					LG002			5					
					109789			5					
D2744		Manufactured	No		110478	110	Each	52.0000	1	1			
D2744									**				
Cap													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					LG001			52					
					100308			28					
					197543			24					
D2739		Manufactured	No			160	Each	11.0000	1	1			
D2739									**				
350 I Beam													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					LG002			11					
					109712			1					
					109973			10					

Picklist Print

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

D2743 Manufactured No 160 Each 331.0000 8 8

D2743

Crossbolt Spacer

**

BE14-01-29

Location	Loc Qty	Loc Code
LG001	331	
106245	9	
107359	68	
107907	122	
109799	132	

D3490-3 Manufactured No 160 Each 160.0000 4 4

D3490-3

Cross Bolt Spacer

**

BE14-01-29

Location	Loc Qty	Loc Code
LG001	160	
103883	14	
105603	3	
107913	63	
109933	80	

D3490-1 Manufactured No 160 Each 225.0000 4 4

D3490-1

Cross Bolt Spacer

**

BE14-01-29

Location	Loc Qty	Loc Code
LG001	225	
107419	57	
109932	168	

D3631-1 Manufactured No 230 Each 12.0000 8 8

D3631-1

Washer

**

BE14-01-29

Location	Loc Qty	Loc Code
FP001	12	
107324	12	

B110258

V8

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

D3791-1

Manufactured No

230

Each

3.0000

1

1

D3791-1

Wearpad

yl 12/02/14

Location

Loc Qty

Loc Code

FP002

3

B109511

yl

106144

3

D3793-3

Manufactured No

230

Each

11.0000

1

1

D3793-3

Wearplate Aft

yl 12/02/14

Location

Loc Qty

Loc Code

FP001

11

104212

11

yl

MS21043-6

Purchased No

230

Each

268.0000

4

4

MS21043-6

NUT

yl 12/02/14

Location

Loc Qty

Loc Code

FG

20

103693

20

ST315

248

m127255

248

yl

D3794-1

Manufactured No

230

Each

13.0000

1

1

D3794-1

Gasket Fwd

yl 12/02/14

Location

Loc Qty

Loc Code

FP001

13

104620

1

108497

5

109207

7

yl

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased No

230

Each

45.0000

8

8

NAS1611-010

O-RING

**

ll m/02/14

Location

Loc Qty

Loc Code

FP001

45

B127813

vg

m126988

45

D2741

Manufactured No

250

Each

39.0000

1

1

D2741

Blade

**

DAS

14-02-20

28

9-89

Location

Loc Qty

Loc Code

FG

11

100664

5

85480

1

98323

5

ST466

28

107206

28

1x

NAS1515H3L

Purchased No

230

Each

54.0000

4

4

***NAS1515H3I ***

Washer

**

ll m/02/14

Location

Loc Qty

Loc Code

FG

40

102472

40

ST297

14

124542

14

vg

NAS1611-013

Purchased No

230

Each

16.0000

8

8

NAS1611-013

O-RING

**

ll m/02/14

Location

Loc Qty

Loc Code

FP001

16

M127813

vg

125445

16

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D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

AN3C6A Purchased No 230 Each 535.0000 4 4

AN3C6A

Bolt

**

Location	Loc Qty	Loc Code
FG	10	
122416	10	
ST513	525	
<u>m125709</u>	525	

NAS1149C0832R Purchased No 230 Each 359.0000 1 1

NAS1149C0832R

Washer

**

Location	Loc Qty	Loc Code
ST292	359	
<u>122441</u>	92	
m114915	117	
m125807	150	

D3536-25 Manufactured No 230 Each 20.0000 1 1

D3536-25

Gasket Center

**

Location	Loc Qty	Loc Code
FG	6	
87053	2	
95328	4	
FP001	14	
109206	14	

D3794-3 Manufactured No 230 Each 17.0000 1 1

D3794-3

Gasket Aft

**

Location	Loc Qty	Loc Code
FP001	17	
<u>108413</u>	17	

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D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

AN3C5A Purchased No 230 Each 164.0000 34 34

AN3C5A

Bolt

**

Handwritten: 11/02/14

Location

Loc Qty

Loc Code

FG	5	11128051	x34
122800	5		
ST350	159		
m127290	159		

D3537-1 Manufactured No 230 Each 20.0000 3 3

D3537-1

Wearpad

**

Handwritten: 11/02/14

Location

Loc Qty

Loc Code

FG	18	B110821	x3
79833	8		
88562	10		
FP001	2		
108118	2		

D3535-25 Manufactured No 230 Each 13.0000 1 1

D3535-25

Wearplate Center

**

Handwritten: 11/02/14

Location

Loc Qty

Loc Code

FG	2		
95077	2		
FP002	11		
106128	11		VI

Picklist Print

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Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

D3492-3

Manufactured No

230

Each

277.0000

8

8

D3492-3

Plug

ll 12/20/13

Location

Loc Qty

Loc Code

FP001

277

104853

72

107331

105

109800

100

x 8

NAS1149C0332R

Purchased No

230

Each

9,547.000

38

38

NAS1149C0332R

WASHER

ll 12/20/13

Location

Loc Qty

Loc Code

GA

1277

125654

1277

st510

8270

m126319

2770

m127306

2500

m127410

3000

x 38

D3488-042

Manufactured No

230

Each

9.0000

1

1

D3488-042

Blade Fitting RH

ll 12/20/13

Location

Loc Qty

Loc Code

FP001

9

B109134

106658

6

98887

3

x 1

Picklist Print

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Purchased

No

230

Each

469.0000

38

38

ALS4-1032-225

Rivnut

Handwritten: 12/20/13

Location

Loc Qty

Loc Code

FG

30

Handwritten: M128179

Handwritten: V38

M127028

30

ST280

10

M127028

10

st555

429

M127092

429

D3492-1

Manufactured

No

230

Each

195.0000

8

8

D3492-1

Plug

Handwritten: 12/20/13

Location

Loc Qty

Loc Code

FP001

195

104844

195

Handwritten: V8

D3793-1

Manufactured

No

230

Each

6.0000

1

1

D3793-1

Wearplate Fwd

Handwritten: 12/20/13

Location

Loc Qty

Loc Code

FP002

6

Handwritten: B110121

Handwritten: X1

109205

6

AN8C35A

Purchased

No

230

Each

75.0000

1

1

AN8C35A

Bolt

Handwritten: 12/20/13

Location

Loc Qty

Loc Code

FG

4

121275

4

FP001

71

m126293

47

m127061

24

Handwritten: X1

Picklist Print

December-20-13 9:07:47 AM

Page 9

Work Order ID: 110475

110475

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

MS21083C8	Purchased	No	230	Each	35.0000	1	1	
MS21083C8								**
Nut								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST319	35	
m127255	35	

D2745	Manufactured	No	230	Each	129.0000	8	8	
D2745								**
Bushing								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST017	129	B110526
106847	5	
107336	124	

AN6C44A	Purchased	No	230	Each	56.0000	4	4	
AN6C44A								**
Bolt								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FG	2	
103964	2	
ST340	50	
123900	50	
ST341	4	
m127300	4	

D3532-1	Manufactured	No	250	Each	86.0000	2	2	
D3532-1								**
Spacer								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST054	86	
100519	26	
109803	60	

DAS
31
9-88

DAS
28
9-89

14-02-20



Picklist Print

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Page 10

Work Order ID: 110475

110475

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

35.0000

2

2

MS21083C8

Nut

DAS
28
9-89

14-02-20

Location

Loc Qty

Loc Code

ST319

35

m127255

35

127813

NAS1149D0863J

DAS
31
9-89

Purchased

No

250

Each

991.0000

2

2

NAS1149D0863J

Washer

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

6

118078

6

ST293

185

125484

185

2x

ST510a

800

125268

600

125635

200

D3493-1

Manufactured

No

250

Each

245.0000

2

2

D3493-1

Washer

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

10

97201

10

ST051

235

105613

16

107916

60

109105

159

2x

***ONLY INSTALL IF INSTALLING ON APICAL
FLOAT SYSTEM***

Picklist Print

December-20-13 9:07:47 AM

Page 11

Work Order ID: 110475

110475

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

AN8C21A

Purchased

No

250

Each

45.0000

2

2

AN8C21A

Bolt

DAS

31

2.89

DAS

28

9.89

14-02-20

Location

Loc Qty

Loc Code

ST

2

123966

2

ST505

43

m127061

43

2x

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN8C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

110475 MCS
13-12-20

RELEASED
2013-08-13
WD

G	CORRECTED TOLERANCE ON Ø0.500 THRU HOLE: IS +0.010/-0.000, WAS +0.100/-0.000 (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1/-4/-5/-6/-7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PART13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MM		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.07.11		

DART AEROSPACE USA, INC.

KENT, WA

DRAWING NO.

D2750

TITLE

350 SKIDTUBE ASSEMBLY

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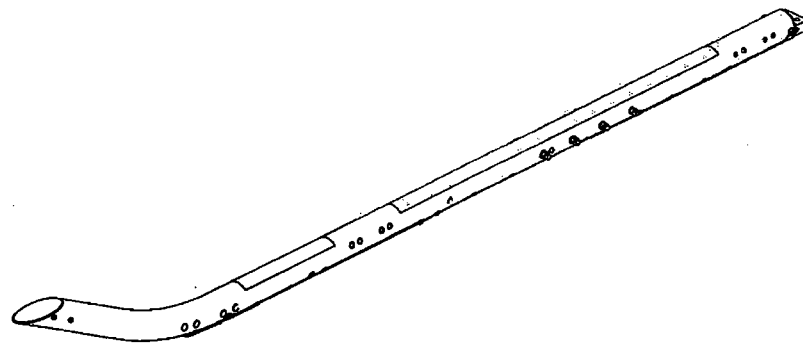
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REV. G

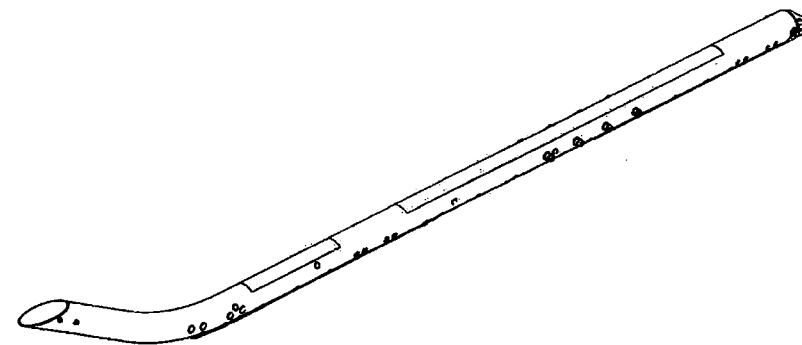
SHEET 1 OF 11

SCALE

NTS



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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MD

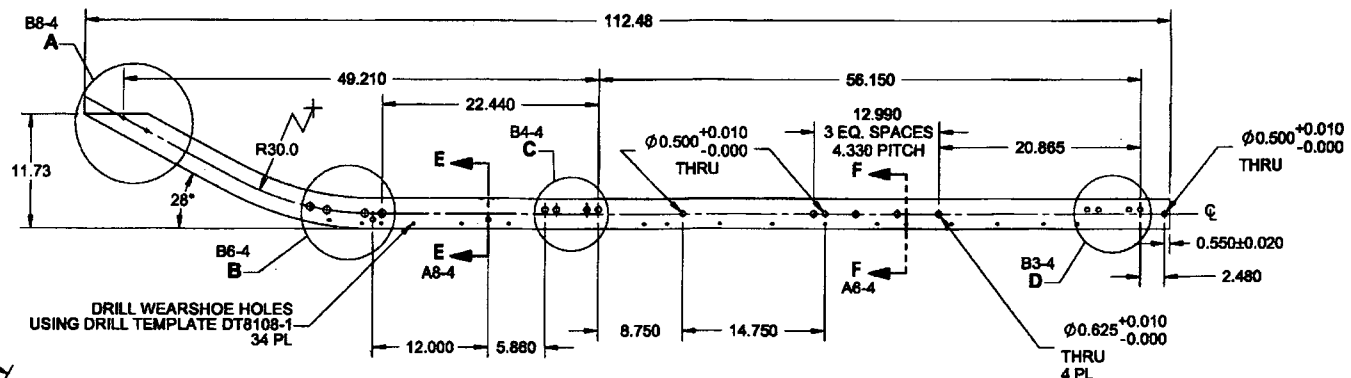
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D2750-043 350 SKIDTUBE ASSEMBLY, LH

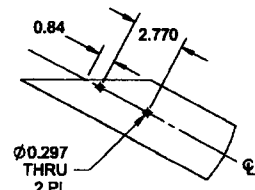
D2750-044 350 SKIDTUBE ASSEMBLY, RH

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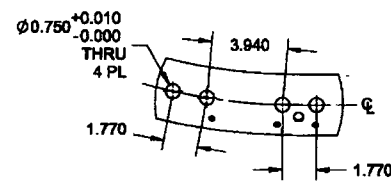
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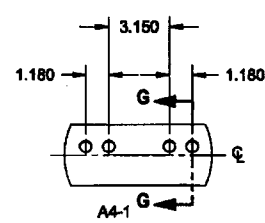
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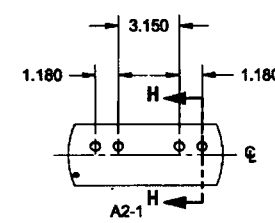
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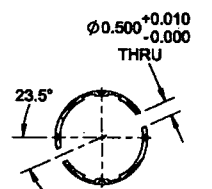
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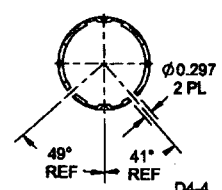
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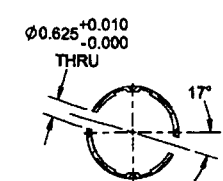
DETAIL D
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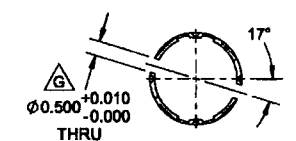
SECTION E-E
SCALE 3X, 2 PL



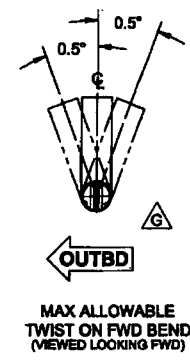
SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



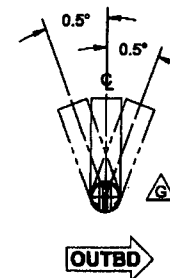
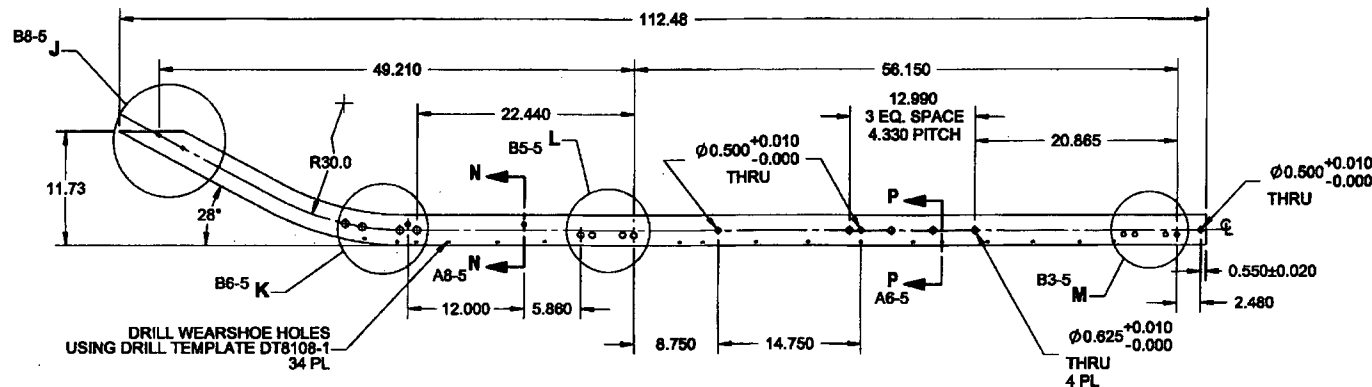
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**MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)**

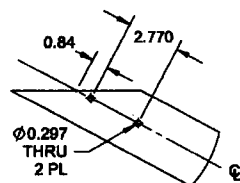
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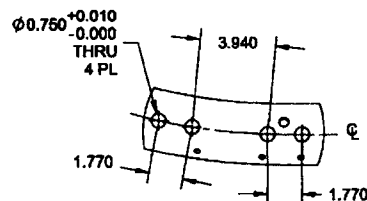


MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)

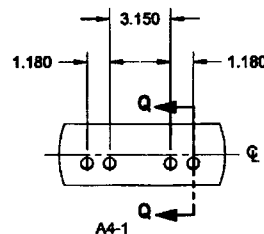
D2750-2 RH SKIDTUBE



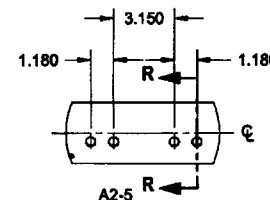
DETAIL J
SCALE 2X



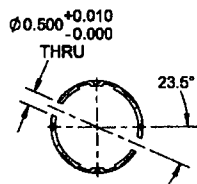
DETAIL K
SCALE 2X



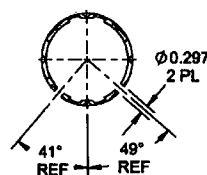
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SCALE 2X



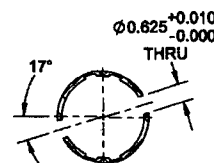
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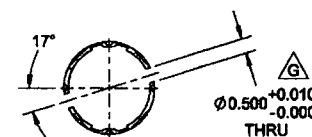
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL

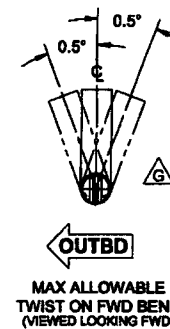
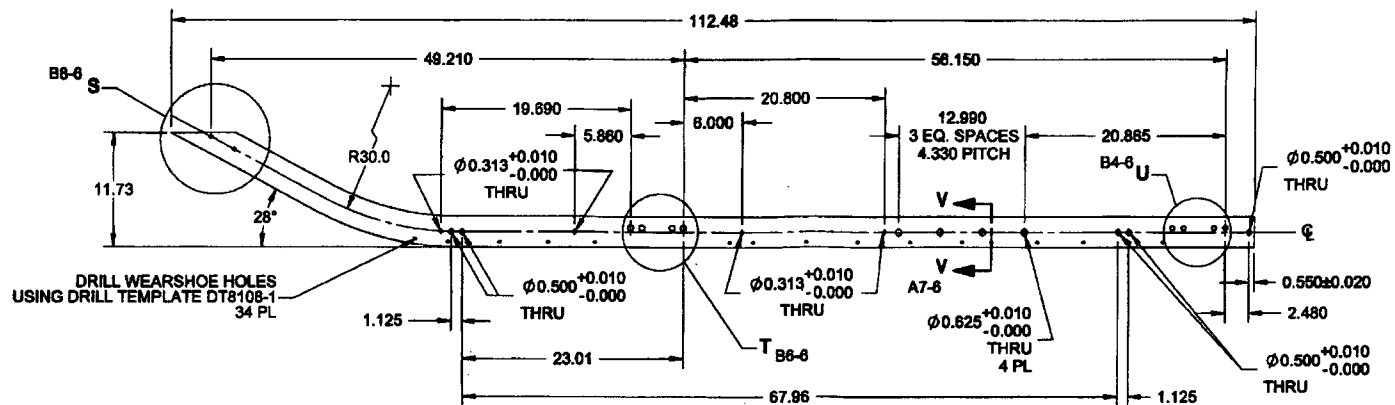


SECTION R-R
SCALE 3X, 4 PL

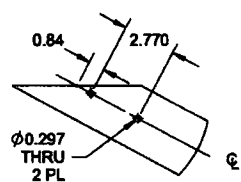
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DE APPR.		SCALE NTB
DATE	13.07.11	

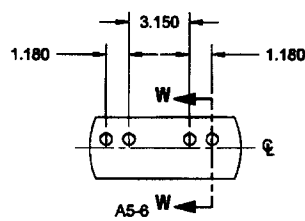
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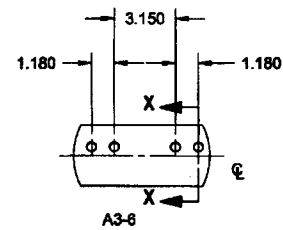
D2750-3 LH SKIDTUBE



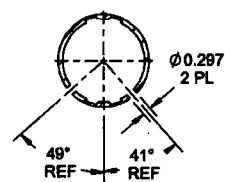
DETAIL S
SCALE 2X



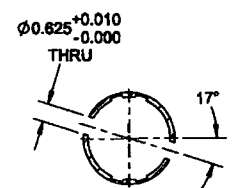
DETAIL T
SCALE 2X



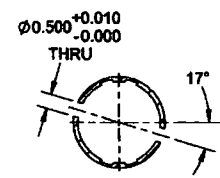
DETAIL U
SCALE 2X



SECTION V-V
SCALE 3X, 17 PL



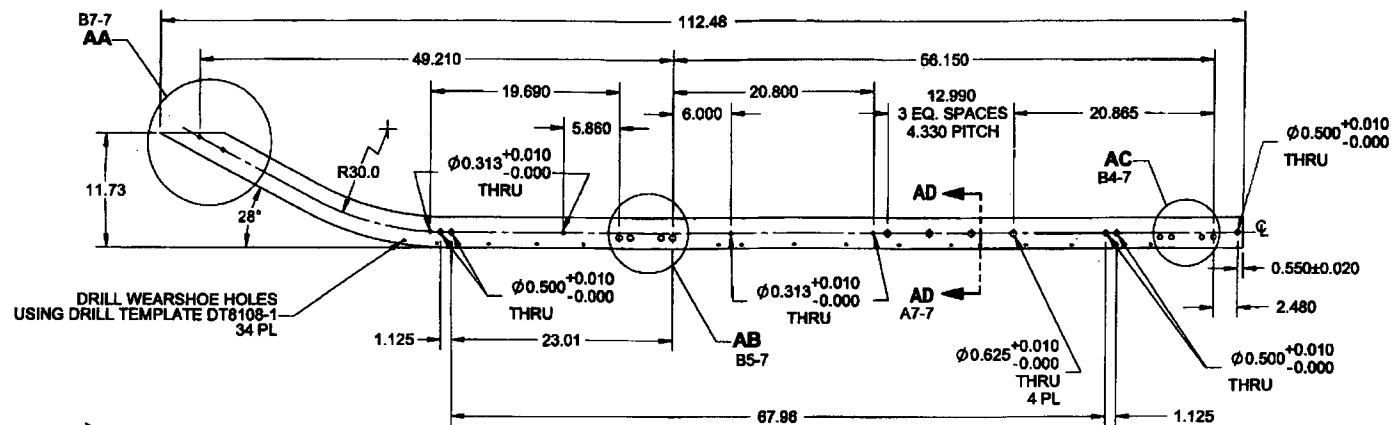
SECTION W-W
SCALE 3X, 4 PL



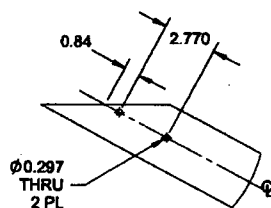
SECTION X-X
SCALE 3X, 4 PL

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2013-08-13

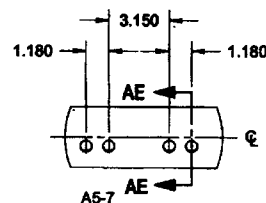
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MFG. APPR.		D2750	SHEET 6 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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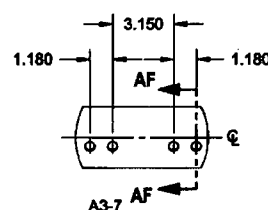
D2750-4 RH SKIDTUBE



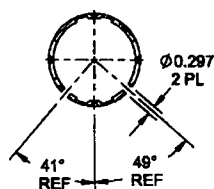
DETAIL AA
SCALE 2X



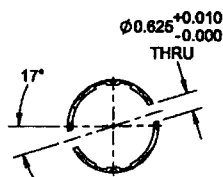
DETAIL AB
SCALE 2X



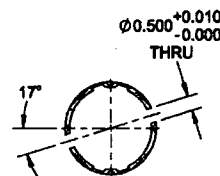
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



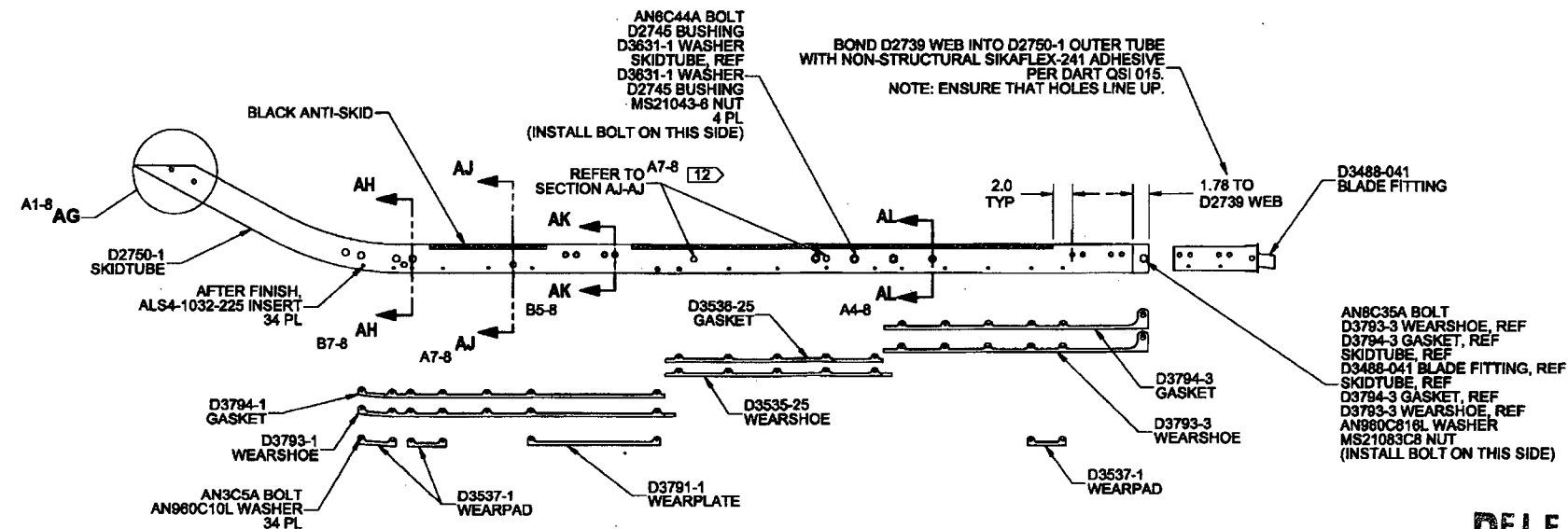
SECTION AE-AE
SCALE 3X, 4 PL



SECTION AF-AF
SCALE 3X, 4 PL

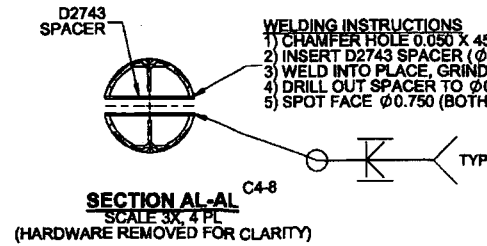
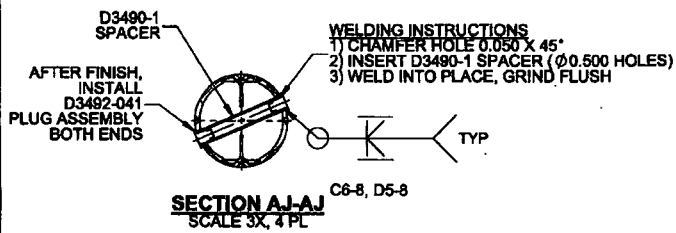
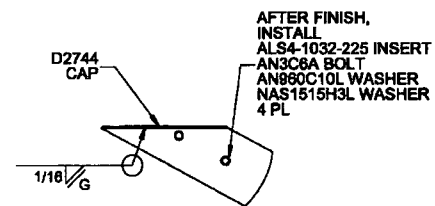
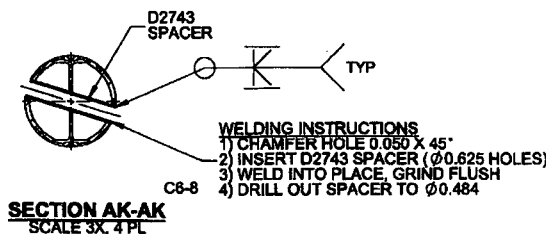
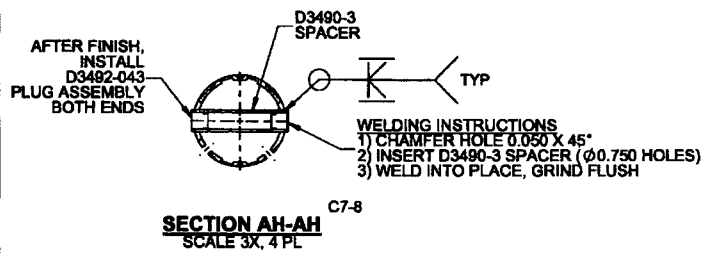
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2013-08-13

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D2750-041 350 SKIDTUBE ASSEMBLY, LH

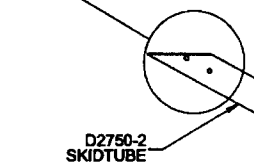
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8 7 6 5 4 3 2 1

A1-9
AM



D2750-2
SKIDTUBE
AFTER FINISH,
ALS4-1032-225 INSERT
34 PL

BLACK ANTI-SKID

(INSTALL NUT ON THIS SIDE)
REFER TO
SECTION AP-AP

AN6C44A BOLT
D2745 BUSHING
D3631-1 WASHER
SKIDTUBE, REF
D3631-1 WASHER
D2745 BUSHING
MS21043-6 NUT
4 PL

BOND D2739 WEB INTO D2750-2 OUTER TUBE
WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE
PER DART QSI 015.
NOTE: ENSURE THAT HOLES LINE UP.

AN
AP
AQ
B7-9
A7-9
B5-9

2.0
TYP

1.78 TO
D2739 WEB

D3488-042
BLADE FITTING

D3794-1
GASKET

D3793-1
WEARSHOE

AN3C5A BOLT
AN660C10L WASHER
34 PL

D3537-1
WEARPAD

D3791-1
WEARPLATE

D3536-25
GASKET

D3535-25
WEARSHOE

D3537-1
WEARPAD

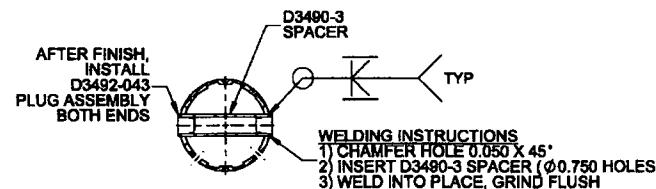
D3794-3
GASKET

D3793-3
WEARSHOE

AN8C35A BOLT
D3793-3 WEARSHOE, REF
D3794-3 GASKET, REF
SKIDTUBE, REF
D3488-042 BLADE FITTING, REF
SKIDTUBE, REF
D3794-3 GASKET, REF
D3793-3 WEARSHOE, REF
AN660C816L WASHER
MS21083C8 NUT
(INSTALL NUT ON THIS SIDE)

RELEASED
2013-08-13

D2750-042 350 SKIDTUBE ASSEMBLY, RH

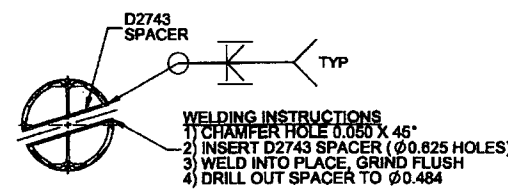


AFTER FINISH,
INSTALL
D3492-043
PLUG ASSEMBLY
BOTH ENDS

WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D3490-3 SPACER (Ø0.750 HOLES)
3) WELD INTO PLACE, GRIND FLUSH

SECTION AN-AN
SCALE 3X, 4 PL

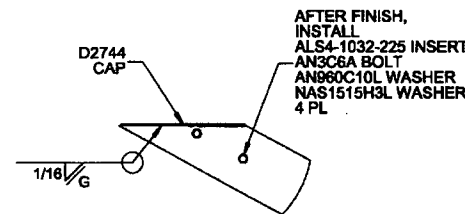
C7-9



WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D2743 SPACER (Ø0.625 HOLES)
3) WELD INTO PLACE, GRIND FLUSH
4) DRILL OUT SPACER TO Ø0.484

SECTION AQ-AQ
SCALE 3X, 4 PL

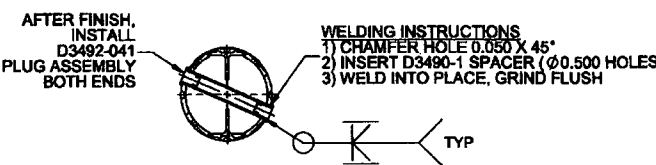
C5-9



AFTER FINISH,
INSTALL
ALS4-1032-225 INSERT
AN3C6A BOLT
AN660C10L WASHER
NAS1515H3L WASHER
4 PL

DETAIL AM
SCALE 2X

D8-9

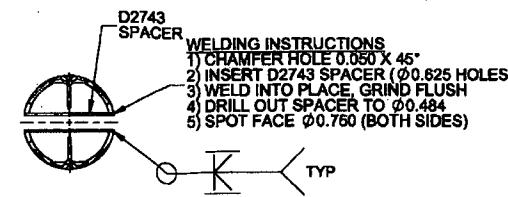


AFTER FINISH,
INSTALL
D3492-041
PLUG ASSEMBLY
BOTH ENDS

WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D3490-1 SPACER (Ø0.500 HOLES)
3) WELD INTO PLACE, GRIND FLUSH

SECTION AP-AP
SCALE 3X, 4 PL

C6-9, D5-9



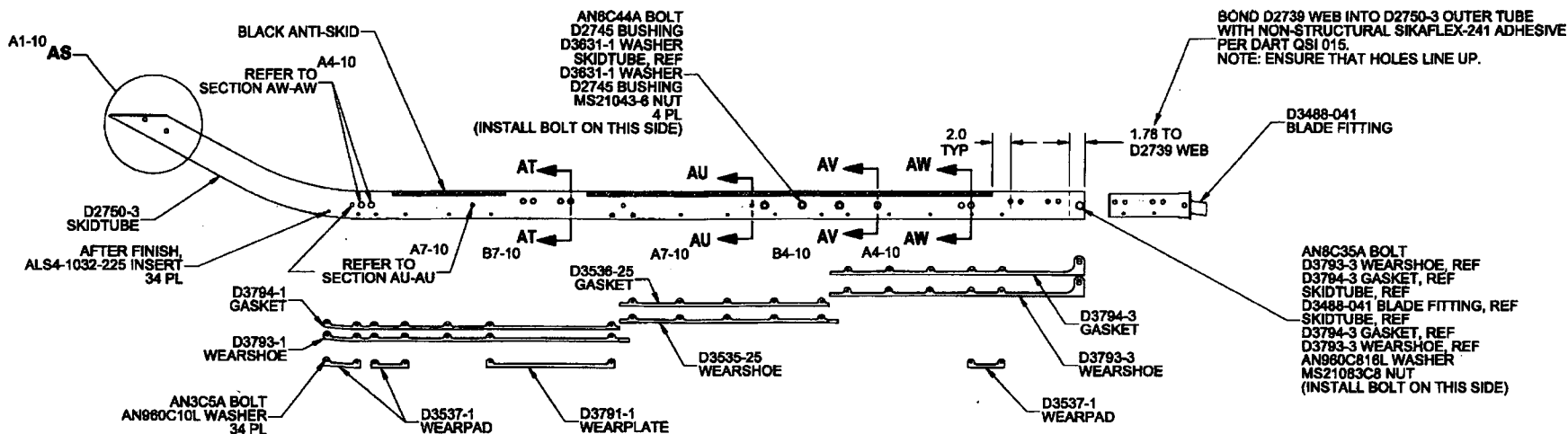
WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D2743 SPACER (Ø0.625 HOLES)
3) WELD INTO PLACE, GRIND FLUSH
4) DRILL OUT SPACER TO Ø0.484
5) SPOT FACE Ø0.750 (BOTH SIDES)

SECTION AR-AR
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

C4-9

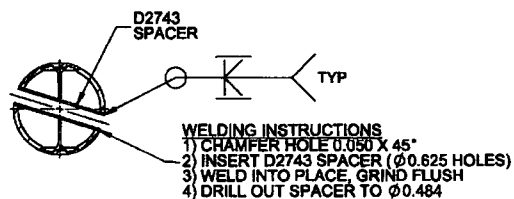
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8 7 6 5 4 3 2 1

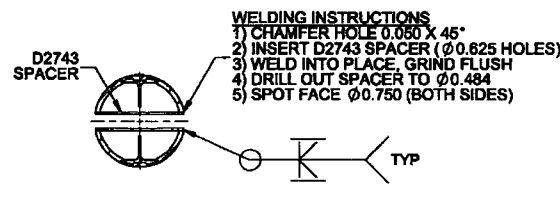


D2750-043 350 SKIDTUBE ASSEMBLY, LH

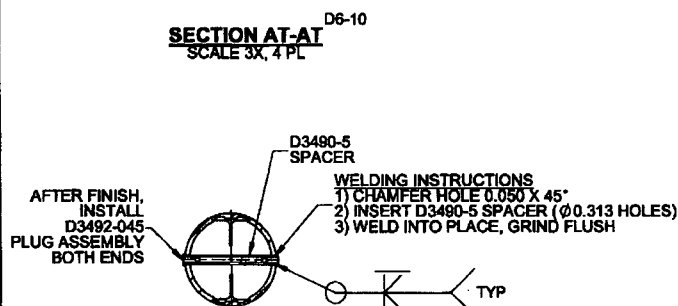
RELEASE
2013-08-13



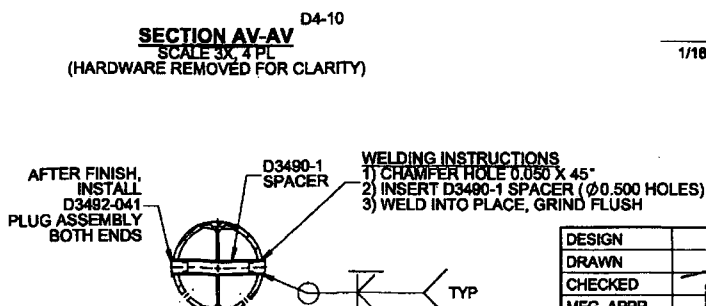
SECTION AT-AT
SCALE 3X, 4 PL



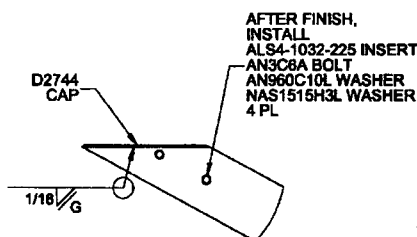
SECTION AV-AV
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION AU-AU
SCALE 3X, 4 PL



SECTION AW-AW
SCALE 3X, 4 PL

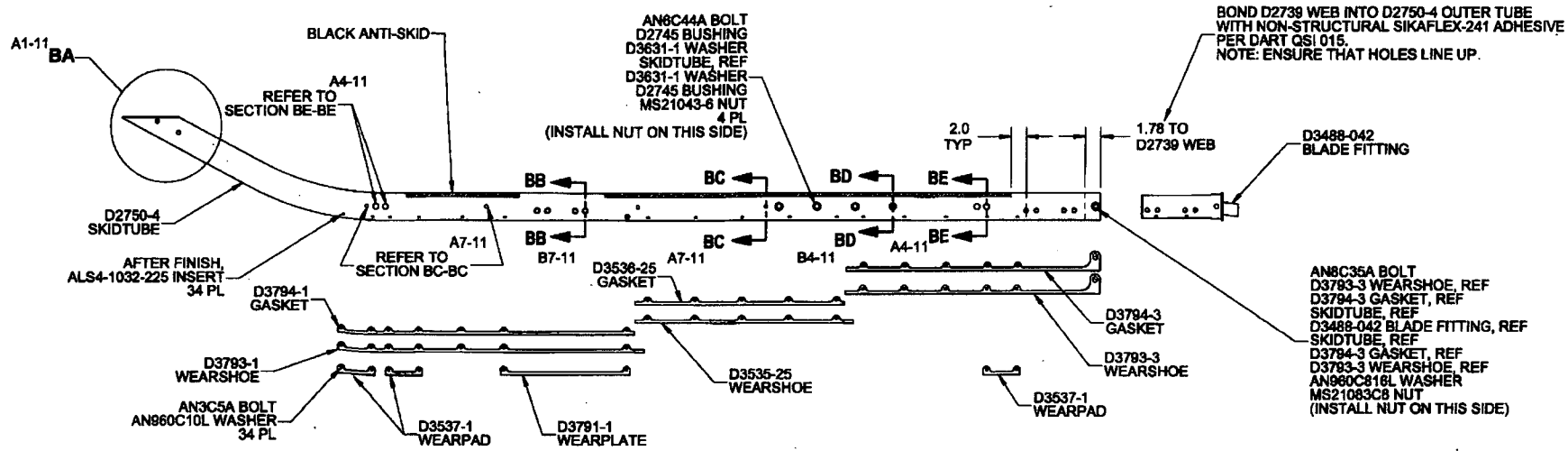


DETAIL AS
SCALE 2X

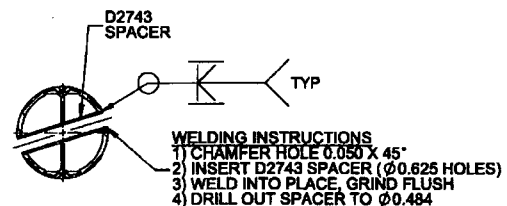
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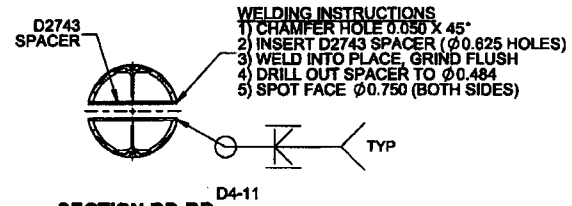
8 7 6 5 4 3 2 1



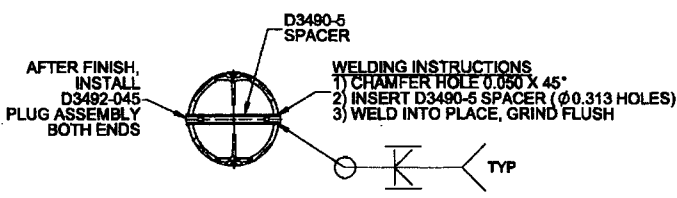
D2750-044 350 SKIDTUBE ASSEMBLY, RH



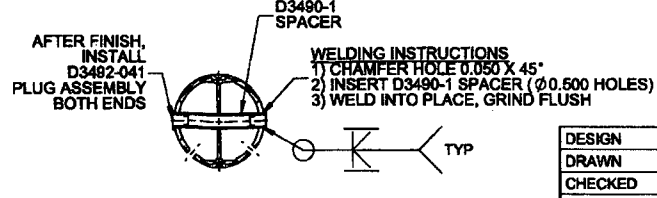
SECTION BB-BB
SCALE 3X, 4 PL



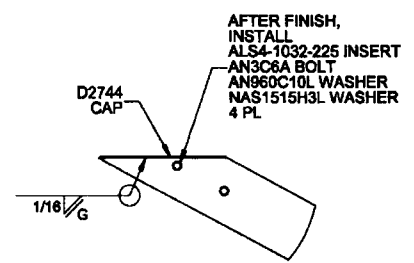
SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL



DETAIL BA
SCALE 2X

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2013-08-13

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Ad Date: 14/03/05QA Closed: Ad Date: 14-3-3

Work Order: <u>110475</u>	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input checked="" type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS			
Part No. <u>R350-636-012</u>		Skid-tube <input checked="" type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
NCR No. <u>14-3590</u>					

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									
	14/1/23	1/0	1	Twist in fwd bend is 88.9° (1.1" off center) RC. Process of Body.	DAS 12 9-89 14/1/23	Acceptable	DAS 12 9-89 14/1/23	S 14/03/03	S 14/03/03

FAULT CATEGORY

Landing Gear <input checked="" type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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No. 337

**AWS D17.1/D17.1M:2010
SKIDTUBE WELDING TEST RECORD**

Name: Barclay Elliott
Job #: D110477
Part #: D350-bbb-012
Description: 350 skid tube
Welding Process: TIG [☒] MIG []
Base Material: Aluminium
Current: AC [☒] DC []

TEST REQUIREMENTS AND RESULTS

Visual:	pass [<input checked="" type="checkbox"/>] fail []
Penetration:	pass [<input checked="" type="checkbox"/>] fail []
Fusion:	pass [<input checked="" type="checkbox"/>] fail []
Cracks:	pass [<input checked="" type="checkbox"/>] fail []
Overlap (cold lap)	pass [<input checked="" type="checkbox"/>] fail []
Undercut:	pass [<input checked="" type="checkbox"/>] fail []
Pin holes:	pass [<input checked="" type="checkbox"/>] fail []
Porosity (surface):	pass [<input checked="" type="checkbox"/>] fail []
Coloration:	pass [<input checked="" type="checkbox"/>] fail []
Burn through:	pass [<input checked="" type="checkbox"/>] fail []

Qualifier: Barclay Elliott

Date of Test Coupon: 14-06-30

Welder: Barclay Elliott

Date of Test Coupon: 14-06-30

The above named individual is qualified to weld in accordance with AWS D17.1/D17.1M:2010.